

20/05/2008

Dart Aerospace Ltd.

Date: Thursday, 01/05/2008 4:16:27 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HEAD REST  
 Job Number : 38967  
 Estimate Number : 10738  
 P.O. Number :  
 This Issue : 01/05/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run : 35437  
 Part Number : D3303041  
 Drawing Number : D3303 REV.B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 16/05/2008 Qty: ~~10~~ 8 Um: Each  
 Written By :  
 Checked & Approved By : JVO 08.5.02  
 Comment : Est: B 04.10.05 Revised Step 5 with headrest identification K  
 J/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3303043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

BRACKET ASSEMBLY

Pick:

Qty	Part Number	Description
1	D3303-043	Bracket Assembly

Batch

B38969

\* New Batch

AS 08/05/20 (x8)

2.0 D33051 Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

FOAM CUSHION

Pick:

Qty	Part Number	Description	Batch
1	D3305-1	Cushion	B29945

Batch

B29945

AS 08/05/20 x10

3.0 D3306041 Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

COVER ASSEMBLY

Pick:

Qty	Part Number	Description
1	D3306-041	Cover Assembly

Batch

B29941

B38969

AS 08/05/20 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 4:16:27 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 38967

Part Number: D3303041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L or 8046 adhesive.  
Identify as D3303-041

A/R 3M 1300/1300L Adhesive Batch: M 102890

2- Cover Head Rest with D3306-041 as per Dwg D3303

SB 08/05/23  
FF  
EB 08/05/23

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/05/23 (X8)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock  
Location: \_\_\_\_\_

SB 08/05/23 (8)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/23

Job Completion



MF 08-05-23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

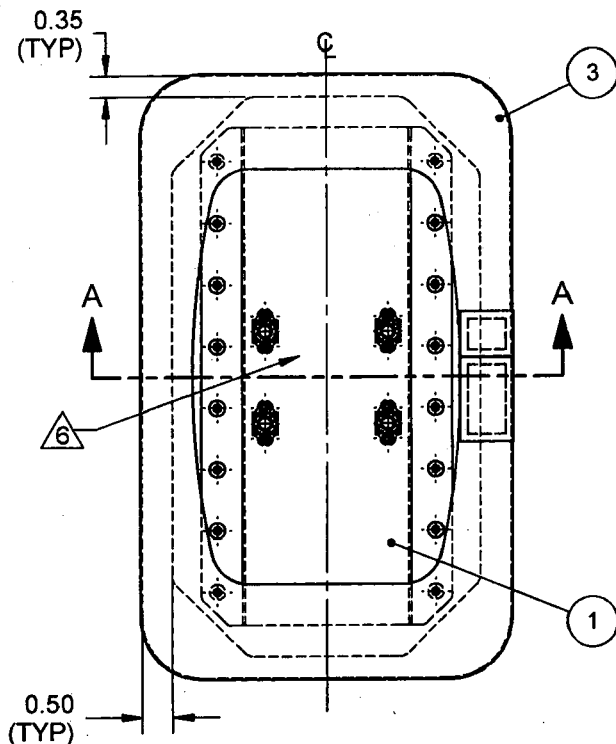
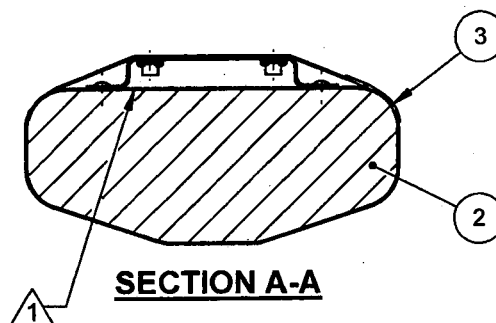
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 1 OF 4
DATE <b>06.08.17</b>		TITLE <b>HEAD REST</b>	SCALE 1:3
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	

**RELEASED**06.09.19 *H***SECTION A-A****D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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**NOTES:**

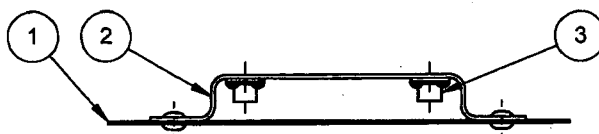
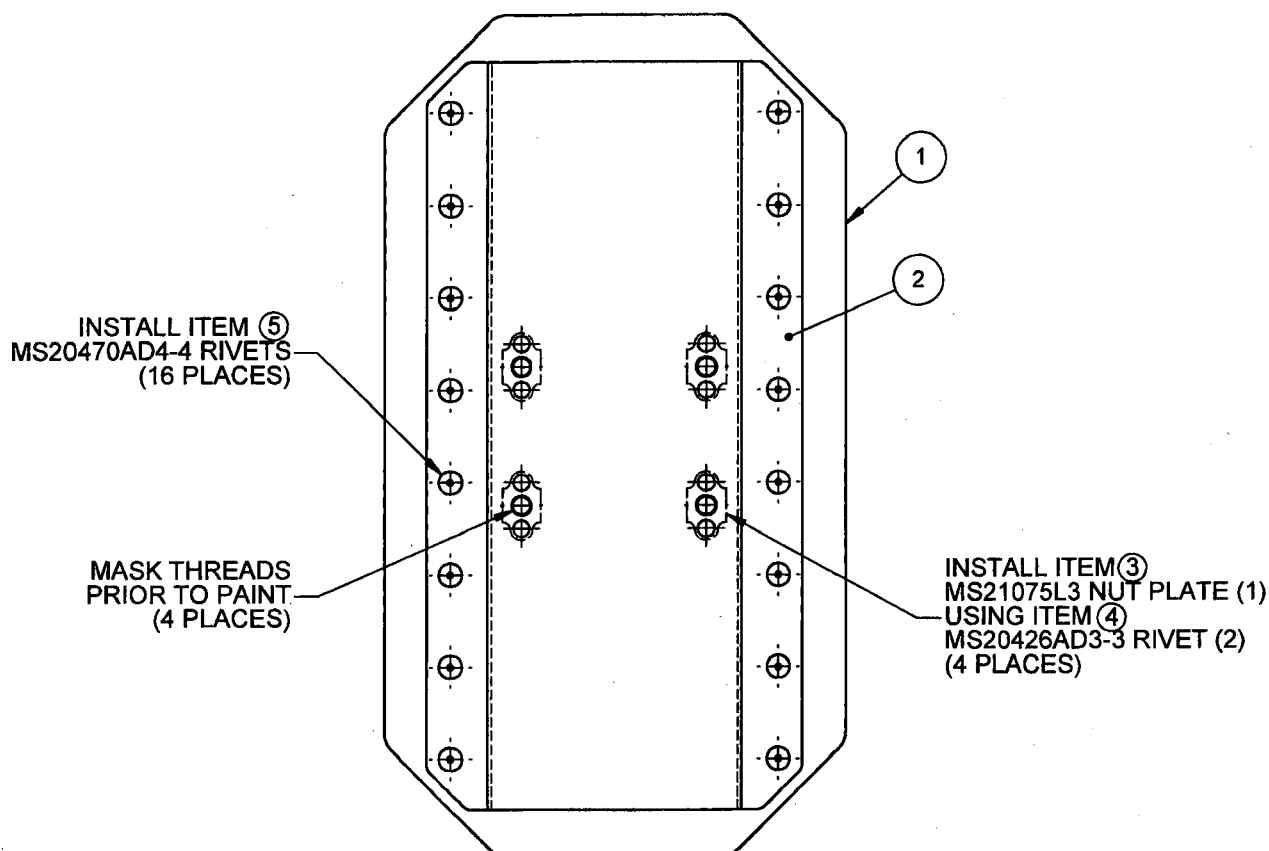
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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DATE <b>06.08.17</b>		TITLE <b>HEAD REST</b>	SCALE 1:2



### D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

#### NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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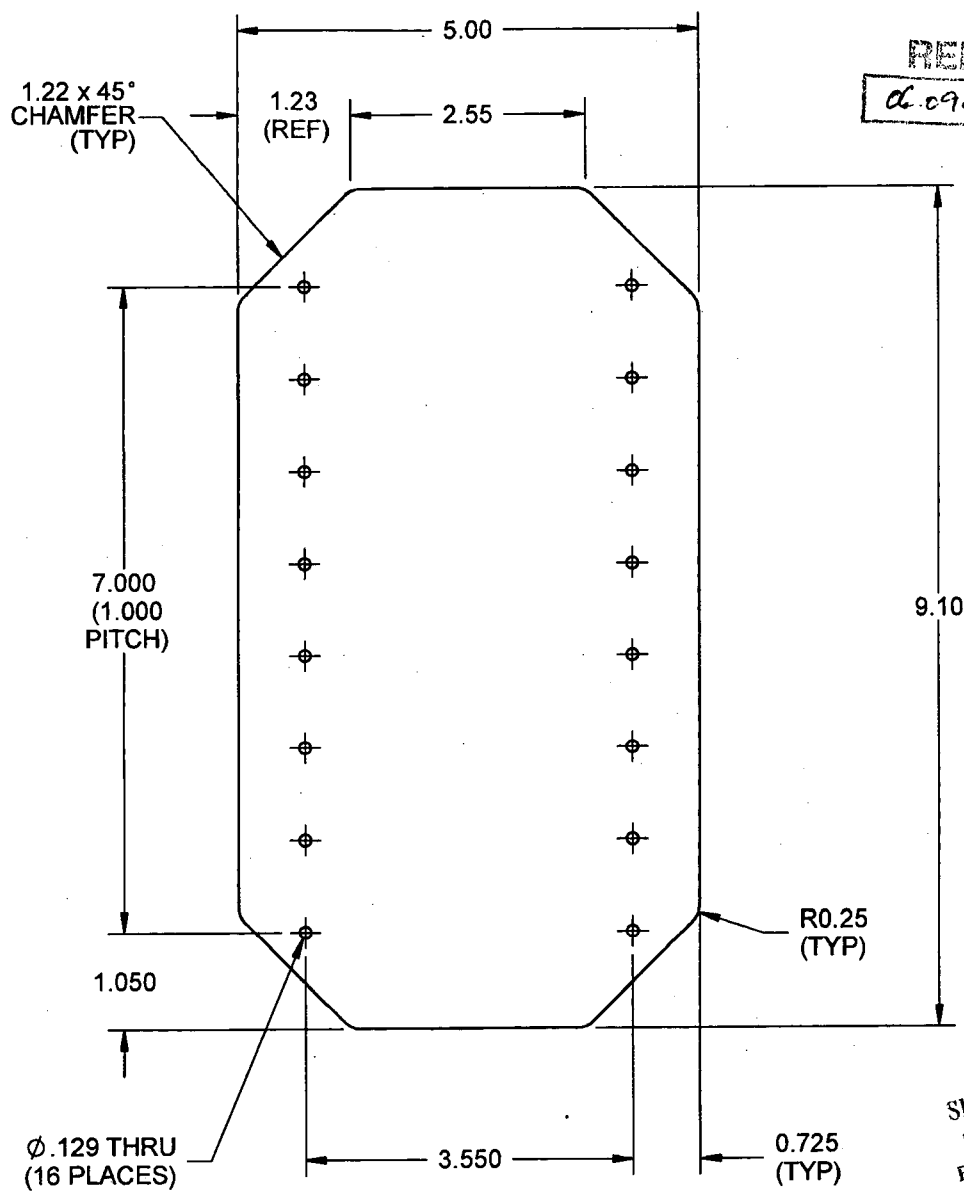
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06.09.19 *PH*

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CHECKED <i>PH</i>	APPROVED <i>AB</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

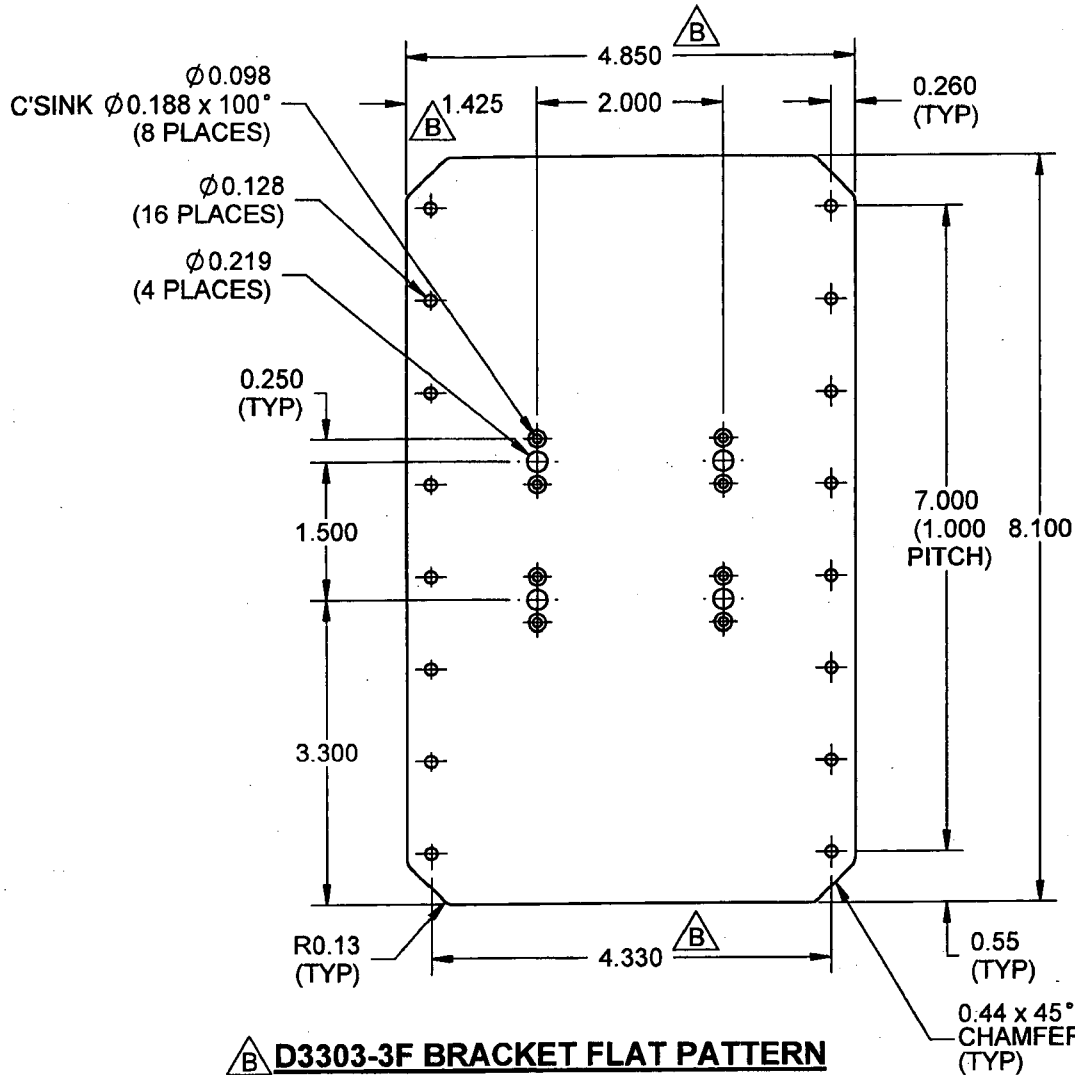
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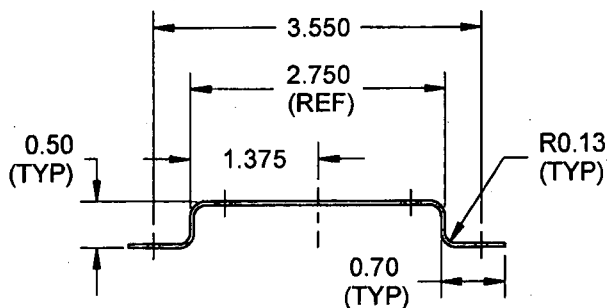
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 4 OF 4
DATE <b>06.08.17</b>		TITLE <b>HEAD REST</b>	SCALE 1:2



**D3303-3F BRACKET FLAT PATTERN**

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06.09.19

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NO. **38967**



**D3303-3 BRACKET BEND DETAIL**

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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